

Work Order ID 61633

Monday, August 30, 2010 3:46:13 PM



Page 1

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Bent

Start Date: 8/30/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00

Customer:

Reference:

Approvals: Process Plan: 

Date: 10-8-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2600	Rev D1								

100

0.00



BENDING MACHINE - SKIDTUBES

CNC Bend 1

Memo

0.00

CNC Delta 100 Bender

Pick qty 1 D2600-3-120 extrusion

1-Deburr one end of extrusion

2-Bend using CNC bending machine as per program 2750.C and Folio 14 use bending aid DT9635

3- cut fwd end of tube as per dwg D2750

4- cut aft end of tube as per dwg D2750

110

QC5- Inspect part completeness to step on W/O

0.00

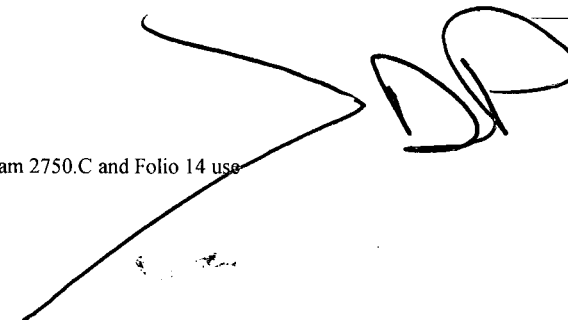


QC

Memo

0.00

Quality Control



10-8-31

45

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 61633

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Page 2

Item ID: D2600-3-BENT

Accept



Setup Start



Revision ID:

Stop



Item Name: Extrusion Bent

Start Date: 8/30/2010 Start Qty: 5.00



Cust Item ID:

Required Date: 9/6/2010 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120



Packaging

Identify as per dwg & Stock Location: 46

0.00

Memo

0.00

10-8-31(5)

130



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/08/31 CL 10/8/31

Quality Control

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, August 30, 2010 3:46:17 PM

Page 1

Work Order ID: 61633



Parent Item: D2600-3-BENT



Parent Item Name: Extrusion Bent


Start Date: 8/30/2010

Required Date: 9/6/2010

Start Qty: 5.00

Required Qty: 5.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-3-120  Extrusion Round 3" 350		Manufactured	No			100	Each	90.0000	1	5			

Location

LG

43960

58480

Loc Qty

90

34

56

Loc Code

5

ND

10-8-31

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 1 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1
A	97.01.21	NEW ISSUE	
B	97.09.09	CHANGE MATERIAL SPEC.	
C	98.04.16	ADD D2600-3, UPDATE D2600-1 WIDTH, ADD DIE NO.	
D	98.08.20	INCREASE MIN. UTS TO 40 KSI	
DI	01.04.17	ADD PART NUMBERS + DIE NUMBERS <i>+CP</i>	

RELEASED
98.08.25 DS

GENERAL NOTES

1. MATERIAL: 6061-T6 (QQ-A-200/8)

MINIMUM YIELD TENSILE STRENGTH = 35 ksi
MINIMUM ULTIMATE TENSILE STRENGTH = 40 ksi
MINIMUM ELONGATION = 8 %

A SAMPLE FROM EACH BATCH WILL BE PULL TESTED
TO ASTM STANDARD B221 BY AN APPROVED TESTING
FACILITY TO ENSURE THAT THE BATCH MEETS THE
ABOVE MINIMUM MECHANICAL PROPERTIES.

2. BREAK ALL SHARP CORNERS 0.010 MAX.
3. NO TOOLING MARKS.
4. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE
NOTED.
5. ALL DIMENSIONS ARE IN INCHES.

CONTROL COPY
RETURN TO
ENGINEERING
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *61433*

8/10-8-30

W/O:		WORK ORDER CHANGES					
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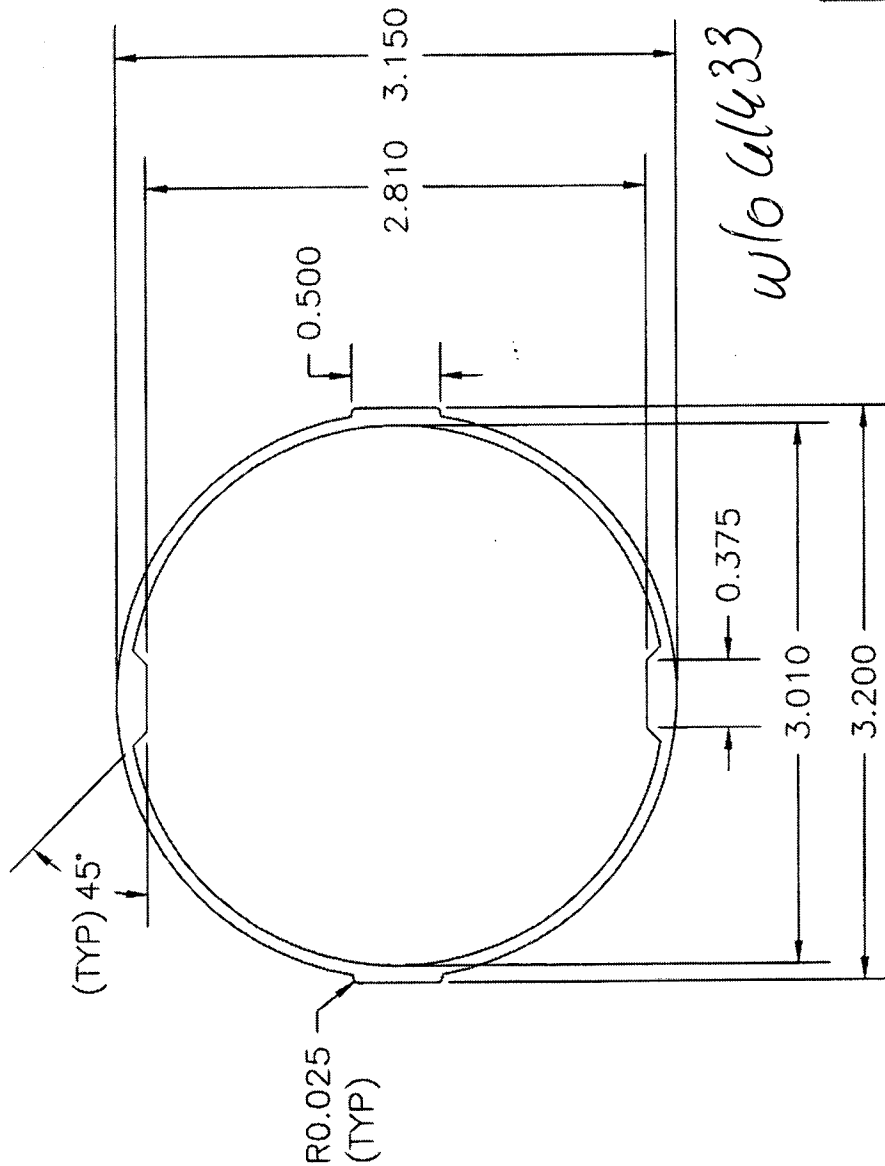
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>DR</i>	DRAWN BY <i>DR</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>KE</i>	DRAWING NO. D2600	REV. D SHEET 2 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS



D2600-1

MANUFACTURED WITH CARADON INDALEX DIE # MH-18870

OR BON L DIE # 897121 (PREFERRED CHOICE)

PART NUMBER IS D2600-1-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-1-160 IS 160" LONG)

Δ_{bl}

W/O:		WORK ORDER CHANGES					
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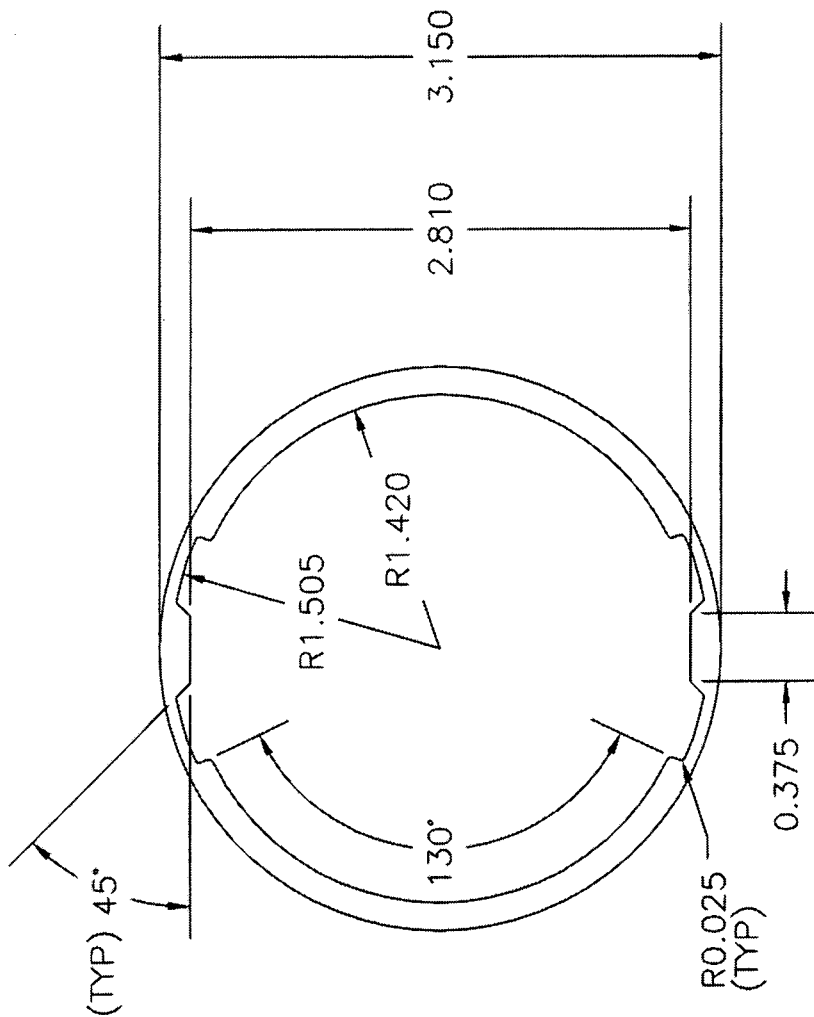
NOTE: Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2600	REV. 0 SHEET 3 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS

wb 61433



D2600-3

MANUFACTURED WITH CARADON INDALEX DIE # MH-18859

OR BON L DIE # 897122 (PREFERRED CHOICE)

PART NUMBER IS D2600-3-XXX WHERE XXX IS CUT LENGTH IN INCHES (EG. D2600-3-120 IS 120" LONG)



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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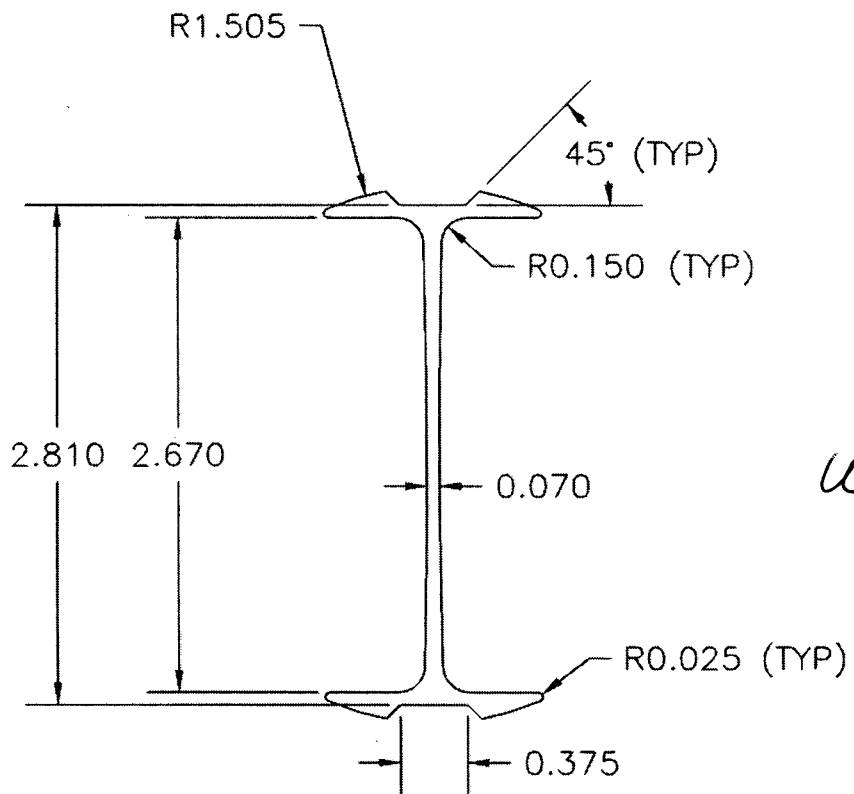
NOTE: Date & initial all entries



DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED	APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE	TITLE	REV. D
98.08.20	D2600	SHEET 4 OF 5
	EXTRUSION	SCALE
		1:1

RELEASED
98.8.25 DS

W10 61433



D2600-5

MANUFACTURED WITH CARADON INDALEX DIE # MS-18871

PART NUMBER IS D2600-5-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-5-108 IS 108" LONG)



W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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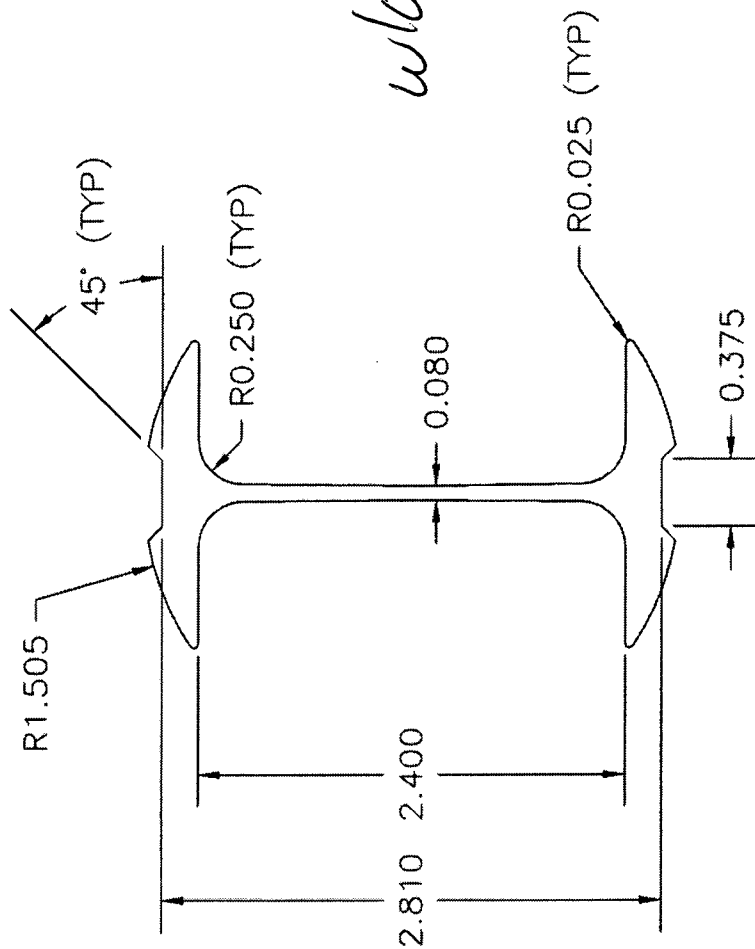
NOTE: Date & initial all entries



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CHECKED <i>KE</i>	APPROVED <i>AS</i>	DRAWING NO. D2600	REV. D SHEET 5 OF 5
DATE 98.08.20		TITLE EXTRUSION	SCALE 1:1

RELEASED
98.8.25 DS

w1061633



D2600-7

MANUFACTURED WITH CARADON INDALEX DIE # MS-18872
PART NUMBER IS D2600-7-XXX WHERE XXX IS CUT LENGTH IN INCHES
(EG. D2600-7-125 IS 125" LONG)



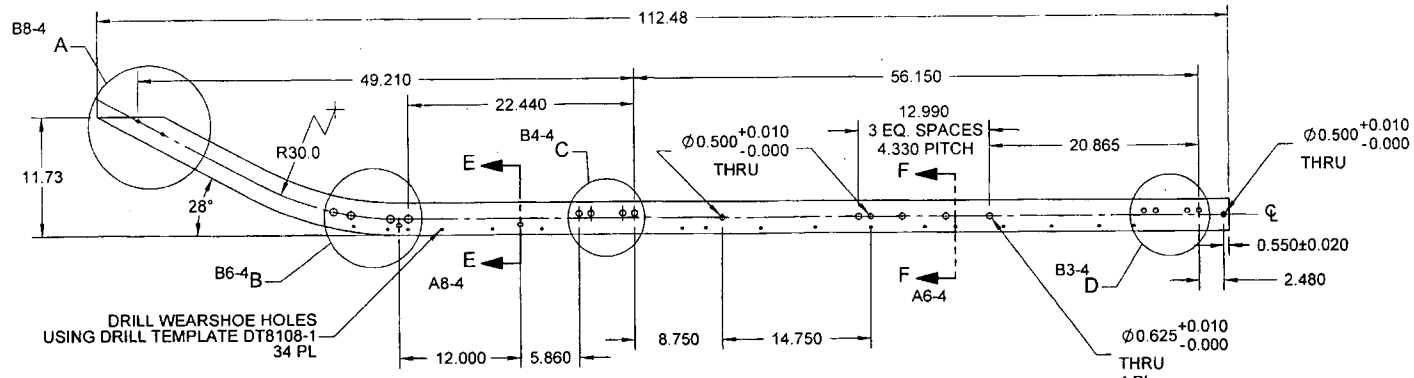
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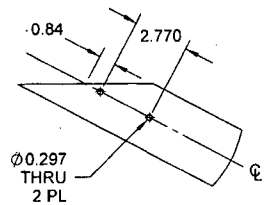
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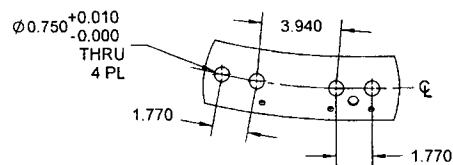
NOTE: Date & initial all entries



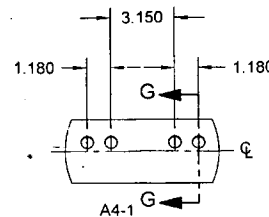
D2750-1 LH SKIDTUBE



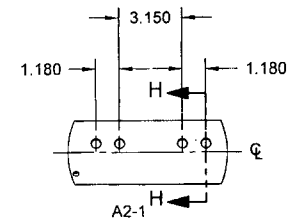
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SCALE 2X



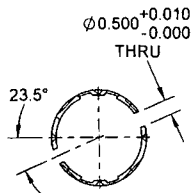
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SCALE 2X



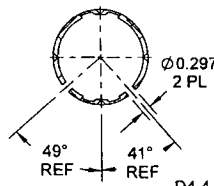
DETAIL C
SCALE 2X



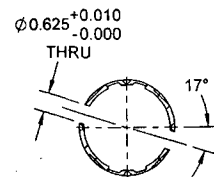
DETAIL D
SCALE 2X



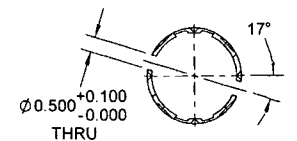
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

DESIGN	100	DART AEROSPACE USA, INC.	
DRAWN	100	PORT HADLOCK, WA	
CHECKED		DRAWING NO. D2750	REV. F
MFG. APPR.			SHEET 4 OF 11
APPROVED		TITLE 350 SKIDTUBE ASSEMBLY	SCALE
DE APPR.			NTS
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